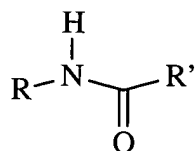


**WHAT IS CLAIMED IS:**

1. A toner comprised of a sulfopolyester resin, a colorant and an alkyl amide.

2. A toner in accordance to **claim 1** wherein said alkyl amide is represented by the formula



wherein R is a hydrogen atom, an aliphatic saturated hydrocarbon or an unsaturated hydrocarbon, each optionally with from about 2 to about 100 carbon atoms, and R' is an aliphatic saturated hydrocarbon or an unsaturated hydrocarbon, each optionally with from about 2 to about 100 carbon atoms.

3. A toner in accordance to **claim 1** wherein said alkyl amide has a melting point of from about 60°C to about 140°C.

4. A toner in accordance to **claim 1** wherein said alkyl amide has a melting point of from about 95°C to about 125°C.

5. A toner in accordance to **claim 1** wherein the alkyl amide is stearyl stearamide or stearyl erucamide.

6. A toner in accordance to **claim 1** wherein said sulfopolyester is selected from the group consisting of the sodium or lithium salt of copoly(1,2-propylene-dipropylene-5-sulfoisophthalate)-copoly (1,2-propylene-dipropylene terephthalate), copoly(1,2-propylene-diethylene-5-sulfoisophthalate)-copoly(1,2-propylene-diethylene terephthalate), copoly(1,2-dipropylene-5-sulfoisophthalate)-copoly(1,2-propylene terephthalate), copoly(1,3-butylene-5-sulfoisophthalate)-copoly (1,3-butylene terephthalate), copoly(1,2 dipropylene-5-sulfoisophthalate)-copoly(1,2-propylene terephthalate), copoly(1,3-butylene-5-sulfoisophthalate)-copoly(1,3-butylene terephthalate), and copoly(1,2-propylene-diethylene-5-sulfoisophthalate)-copoly(1,2-propylene-diethylene terephthalate).

7. A toner in accordance to **claim 1** wherein said sulfopolyester resin possesses a number average molecular weight of from about 2,000 grams per mole to about 100,000, or about 20,000 to about 75,000 grams per mole, a weight average molecular weight of from about 25,000 to about 125,000 or from about 4,000 grams per mole to about 250,000 grams per mole, and a polydispersity of from about 1.8 to about 17 as measured by gel permeation chromatography.

8. A toner in accordance to **claim 1** wherein the sulfopolyester resin has a glass transition temperature of from about 50°C to about 65°C.

9. A process for the preparation of toner comprising heating an aqueous dispersion of an alkyl amide, a sulfonated polyester resin, and a colorant; adding thereto a solution of an alkaline earth metal salt or a transition metal salt whereby the coalescence and ionic complexation of said sulfonated polyester colloid, colorant, alkyl amide and a metal cation generated from said metal salt is accomplished.

10. A process in accordance to **claim 9** wherein the aqueous dispersion of said alkyl amide is prepared utilizing a homogenizer at from about 100°C to about 140°C and at a pressure of from about 1,000 to about 8,000 psi for an optional duration of from about 5 to about 120 minutes.

11. A process in accordance to **claim 9** wherein said colloidal solution of a said sulfonated polyester resin is prepared by heating water to a temperature of from about 85°C about 95°C, and adding thereto said sulfonated polyester resin, followed by cooling to about room temperature, about 23°C to about 25°C.

12. A process in accordance to **claim 9** wherein said alkyl amide dispersion and said sulfopolyester are mixed with a colorant at a temperature of from about 50°C to about 60°C followed by adding thereto an aqueous solution of an alkaline earth metal (II) salt or a transition metal salt, and whereby the coalescence and ionic complexation of said sulfonated polyester, colorant, alkyl amide and metal cation occur until the particle size of the resulting composite is about 3 to about 10 microns in volume average diameter with a geometric distribution of from about 1.13 to about 1.23.

13. A toner in accordance with **claim 1** wherein the colorant is carbon black.

14. A toner in accordance with **claim 1** wherein the colorant is cyan, magenta, yellow, black, or mixtures thereof.

15. A toner in accordance with **claim 1** wherein the sulfopolyester resin is selected in an amount of from about 75 to about 90 weight percent of the toner, the colorant is selected in an amount of from about 3 to about 15 weight percent of the toner, the alkyl amide is selected in an amount of from about 5 to about 20 percent by weight, and wherein the total of said components is 100 weight percent of the toner.

16. A toner in accordance with **claim 1** wherein the alkyl amide is ethylamide, propylamide, butylamide, pentylamide, hexylamide, cyclohexylamide, octylamide, dodecylamide, hexadecylamide, octadecylamide, oleamide, eucamide, stearamide, behenamide; secondary monoamide examples are behenyl benenamide, stearyl stearamide stearyl oleamide, stearyl eucamide, eucryl stearamide, behenyl behenamide, ethylene bis(oleamide), or ethylene bis(stearamide).

17. A toner in accordance to **claim 16** wherein the sulfopolyester resin is the sodium salt of copoly(1,2-propylene-dipropylene-5-sulfoisophthalate)-copoly(1,2-propylene-dipropylene terephthalate) or lithium salt of copoly(1,2-propylene-diethylene-5-sulfoisophthalate)-copoly (1,2-propylene-diethylene terephthalate) in an amount of from about 70 to about 75 weight percent of toner; the alkylamide is stearyl stearamide or stearyl eucamide in an amount of from about 10 to about 15 weight percent, and the colorant is cyan, black, magenta or yellow, each present in an amount of from about 5 to about 12 weight percent of toner.

18. A developer comprised of the toner of **claim 1** and carrier.

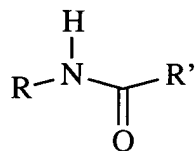
19. A developer comprised of the toner of **claim 16** and carrier.

20. A toner in accordance with **claim 1** wherein alkyl contains from about 1 to about 25 carbon atoms, or from about 1 to about 12 carbon atoms.

21. A toner in accordance with **claim 1** wherein alkyl contains from about 1 to about 5 carbon atoms.

22. A toner in accordance with **claim 1** wherein said amide is stearyl stearamide, and said sulfopolyester is the sodio salt of (1,2-propylene-dipropylene-5-sulfoisophthalate)-copoly(1,2-propylene-dipropylene terephthalate).

23. A toner comprised of a polymer, colorant and an alkyl amide of the formula



wherein R is a hydrogen atom, an aliphatic saturated hydrocarbon or an unsaturated hydrocarbon, each with from about 2 to about 100 carbon atoms, and R' is an aliphatic saturated hydrocarbon or an unsaturated hydrocarbon, each with from about 2 to about 100 carbon atoms.

24. A toner in accordance with **claim 23** wherein said resin is a sulfonated polyester, and said hydrocarbons each contain from about 5 to about 75 carbon atoms.

25. A toner in accordance with **claim 23** wherein said resin is a sulfonated polyester, and said hydrocarbons each contain from about 25 to about 50 carbon atoms.

26. A toner in accordance with **claim 1** wherein said resin is a sulfonated polyester, and said hydrocarbons each contain from about 5 to about 75 carbon atoms.